

Work Order ID 70317

Thursday, June 02, 2011 2:45:21 PM

Page 1

Item ID: D3204-3

Accept

Revision ID:

Item Name: Arm

Start Date: 6/8/2011 Start Qty: 6.00

Required Date: 6/17/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

ant 11/06/09

6 8

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA344 and Dwg D3204112- Deburr Identify as D3204-3

ant 11/06/09

6 8

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ant 11/06/09

6 8

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

20 11. C. 10 6 4

140

Identify as per dwg & Stock Location: CARL

0.00



Packaging

Memo

0.00

Packaging

10 11/6/13 6

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13 4

C211106/13

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 2:45:18 PM

Page 1

Work Order ID: 70317

Parent Item: D3204-3

Parent Item Name: Arm



Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: [C] 05.08.11 [Added Step 25] [KJ/JLM]

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.00 0		Purchased	No			100	f	22.0000	0.5538	3.497684			



6061-T6 Bar .500 x 2.00



Location

Loc Qty

Loc Code

MAT002

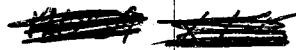
22

→ 110167

2

114488

20



2.
1.5

GR 6/4/09

W/O:		WORK ORDER CHANGES							
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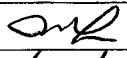

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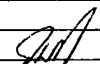

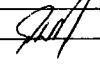
DART AEROSPACE LTD		Work Order: 70317
Description: Arm		Part Number: D3204-3
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	6.000	—		vern 46-7	
5.25	+/-0.030	5.250	—		"	
0.776	+/-0.010	.776	—		"	
Ø0.760	+0.005/-0.000	Ø.761	—		"	
0.080	+/-0.010	.080	—		"	
R0.50	+/-0.010	R.500	—		"	
2.373	+/-0.010	2.371	—		"	
0.750	+/-0.010	.750	—		"	
R0.380	+/-0.010	R.380	—		"	
Ø0.375	+0.001/-0.000	Ø.376	—		"	
0.300	+/-0.010	.300	—		"	

Measured by: 	Audited by: 	Prototype Approval: N/A
Date: 11/06/09	Date: 11.6.10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM 	

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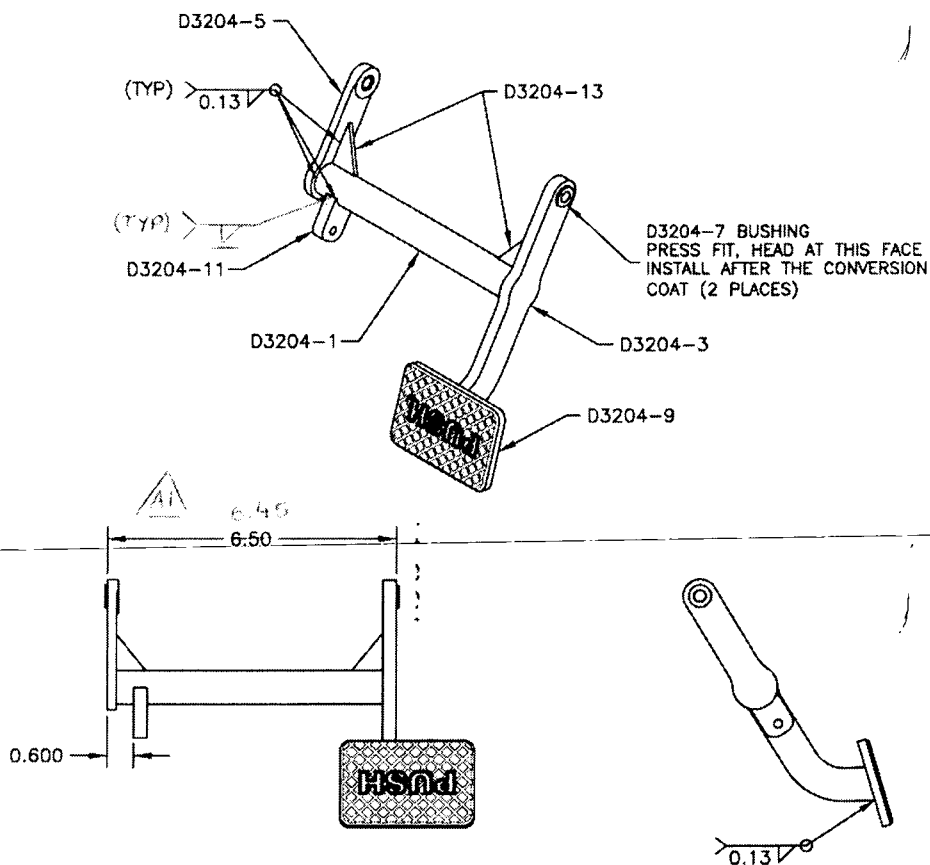
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI # 05 07 15 6.45 WAS 6.50			

RECEIVED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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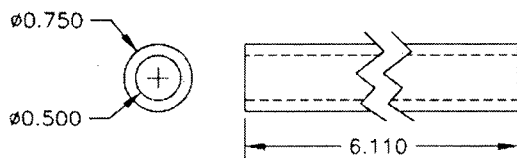
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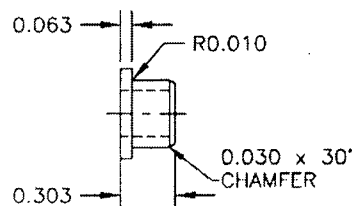


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

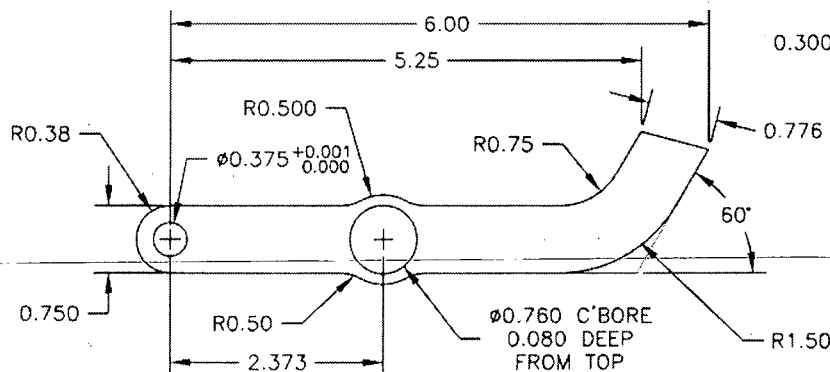
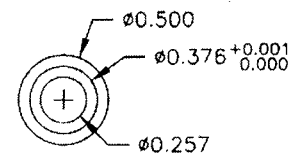
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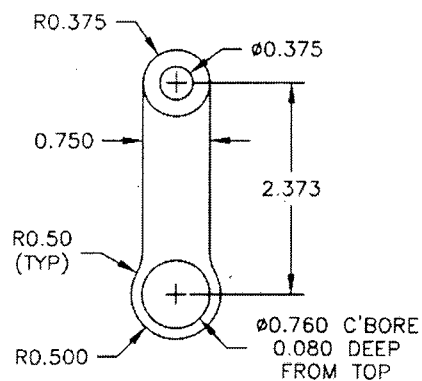
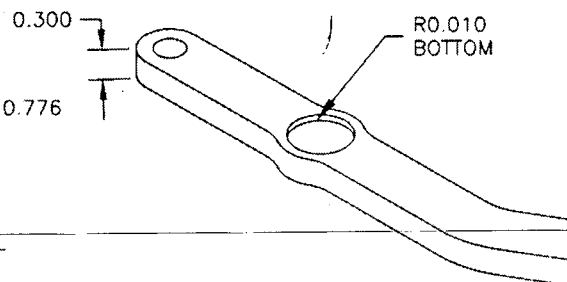
2 D3204-1 TUBE
SCALE 1:2



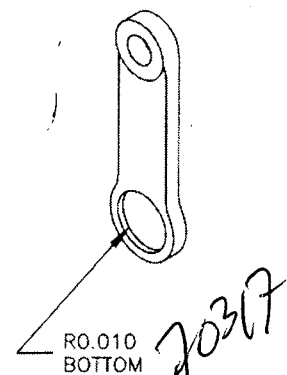
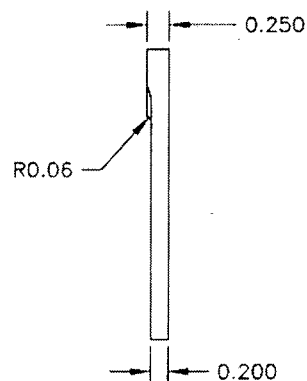
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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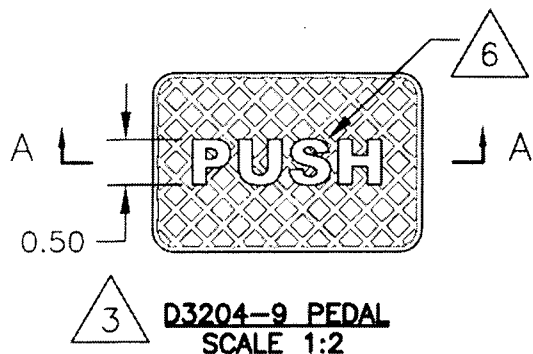
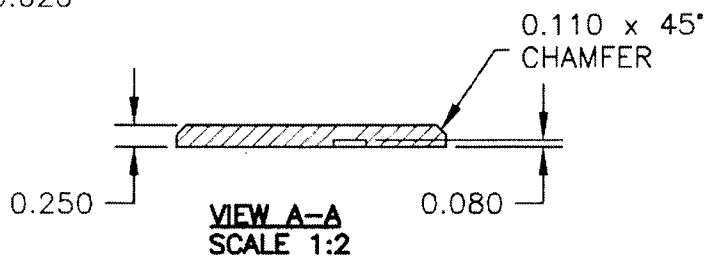
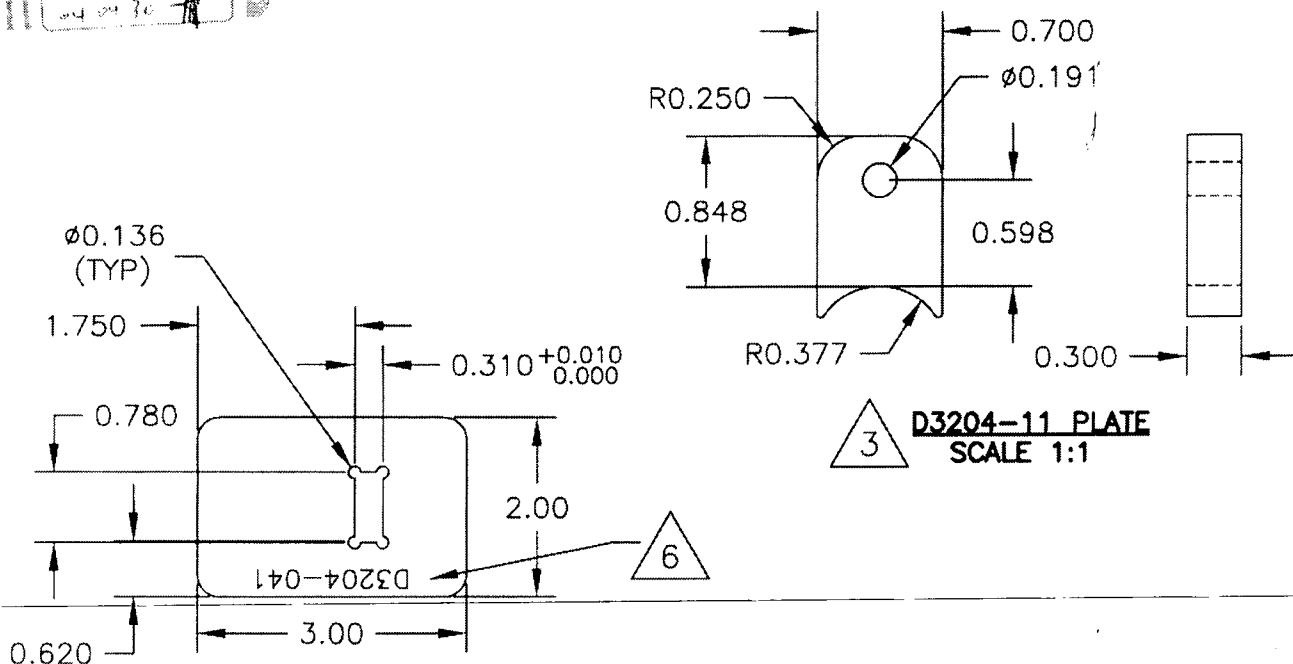
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04 04 70



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